

Work Order ID 124019

124019

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September-05-14 1:42:35 PM

Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
 Start Date: 9/05/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11-09-05 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

100 Document Control 0.00
 100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork
 record fwd angle: 89.6° DGC
 Photocopy blue file and type labels per PPP D350-636-012 CHG 007
 DAS 46
 9-89
 DEC 10 2014

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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

7- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

SEE
ATTACHED

DGL 14-9-5

Pto

BE 14-09-10

DQA: SA Date: 15/03/25

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: REWORK Date: 15/03/20Work Order update only ☐

Work Order: <u>124019</u> Part No. <u>D350-636-012</u> NCR No. <u>154689</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☒</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☒	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☒	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☒	14/11/21	110	1	BLADE FITTING NOT ALIGNING WITH AFT HOLE RC GMT NOT CONSIDERED Danni Design	DAS 12 989 14/11/21	Acceptable to open aft hole to Ø0.527	 14-11-21	 14-11-21	 15/01/21
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☒ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D350-636-012 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
 Start Date: 9/05/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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A/R Aluminum Rod batch: M129399

9- Grind welds flush as per Dwg D2750

78E14-09-10

120	QC10- Inspect visual per QSI004- ground welds	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC

Quality Control

Memo 0.00

SEP 10 2014

DAS
24
9-89

130	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

130

QC

Quality Control

Memo 0.00

DAS
03
9-89

14-9-10

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 **Start Qty:** 1.00 *** 1 ***

Cust Item ID:

Required Date: 9/05/14 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

0.00

HandFinish

Memo

Hand Finishing

150

QC7-Inspect Chemical Conversion Coat

0.00

150

0.00

QC

Memo

Quality Control

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat. Stop *NS2*

Start Date: 9/05/14 Start Qty: 1.00 *1*

Required Date: 9/05/14 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per OSI 015, let cure for 12hrs.

A/R Sikaflex-291 batch: 129457

exp. date: 14-11-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & OSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: M122399

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11- Spot face ground handling holes section (total of 4 places per side) as per

14-9-12

[Handwritten signature]

7864-09-15

14-5-15

14-5-16

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Item ID: D350-636-012 Accept *N9000040100* Setup Start *NS1*
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750								
	12- Deburr holes, ensure tube is free of all scratches before sending to paint.								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
									DAS 38 9-89 NOV 2 6 2014
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control	***VERIFY C'BOARD IS GOOD***								
									DAS 38 9-89 NOV 2 6 2014 NOV 2 6 2014

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
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 Required Date: 9/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							DAS 41 9-89
200									
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>129568</u>								14-11-30
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>130858</u>								
210	QC14- Inspect Spray Paint	0.00							
210									DAS 15 9-89
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
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 Start Date: 9/05/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>11130227</u>								
	EXP DATE: <u>15/08</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>11129305</u> RTU 548 13611 11125792 exp 15/06								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>11122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	Memo	0.00							
QC									
Quality Control									

DAS
38
9-89

14-12-02

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

DEC 03 2014

DAS
66
9-89

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

DAS

46

9-89

DEC 10 2014

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

DAS

66

9-89

DEC 30 2014

DAS

45

9-89

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 9/05/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/05/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

[Handwritten signature]
15-01-05

Picklist Print

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Page 1

Work Order ID: 124019

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured

No

110

Each

1.0000

1

1

DGC 11-9-9

D2600-3-BENT

Extrusion Bent

Location

Loc Qty

Loc Code

LG002

123633

1

119680

1

D2744

Manufactured

No

110

Each

53.0000

1

1

BE1407-10

D2744

Cap

Location

Loc Qty

Loc Code

LG001

113128

53

115440

52

1

Picklist Print

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Work Order ID: 124019

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

13.0000

1

1

D2739

350 I Beam

Location

Loc Qty

Loc Code

LG

10

123536

10

LG002

3

117245

2

117803

1

① 14-9-12/11

D2743

Manufactured No

160

Each

192.0000

8

8

D2743

Crossbolt Spacer

BE14-09-15

Location

Loc Qty

Loc Code

LG001

192

109799

1

112729

59

119609

58

120481

74

8

D3490-3

Manufactured No

160

Each

72.0000

4

4

D3490-3

Cross Bolt Spacer

BE14-09-15

Location

Loc Qty

Loc Code

LG

72

122458

22

122751

50

4

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No 160 Each 100.0000 4 4

D3490-1

Cross Bolt Spacer

8E14-09-15

Location

Loc Qty

Loc Code

LG	85	
<i>(122457)</i>	85	
LG001	15	
112737	1	
116358	14	

<u>4</u>
<u> </u>
<u> </u>
<u> </u>
<u> </u>

D3631-1 Manufactured No 230 Each 126.0000 8 8

D3631-1

Washer

HL 14/12/14

Location

Loc Qty

Loc Code

FP001	126	
110258	16	
119553	10	
123452	100	

B125912

<u>20</u>
<u> </u>
<u> </u>
<u> </u>
<u> </u>

D3791-1 Manufactured No 230 Each 6.0000 1 1

D3791-1

Wearpad

HL 14/12/14

Location

Loc Qty

Loc Code

FP001	1	
92689	1	
FP002	5	
118942	5	

B125913

<u>VI</u>
<u> </u>
<u> </u>
<u> </u>

Picklist Print

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Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

8.0000

1

1

D3793-3

Wearplate Aft

all whole

Location

Loc Qty

Loc Code

FP001

1

104212

1

B124146

xc

FP002

7

120141

7

MS21043-6

Purchased

No

230

Each

58.0000

4

4

MS21043-6

NUT

all whole

Location

Loc Qty

Loc Code

FG

20

103693

20

Y1130822

xc

ST306

38

m127255

6

m127813

32

D3794-1

Manufactured

No

230

Each

2.0000

1

1

D3794-1

Gasket Fwd

all whole

Location

Loc Qty

Loc Code

FP001

2

109207

1

B124438

xc

93381

1

Picklist Print

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Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

383.0000

8

8

NAS1611-010

O-RING

**

12/12/01

Location

Loc Qty

Loc Code

FP001

383

1130797

m126988

3

x 8

m127813

4

m128375

10

m129198

44

m129405

82

m129523

240

D2741

Manufactured

No

250

Each

48.0000

1

1

D2741

Blade

DAS

46

9-89

**

DEC 03 2014

DAS

86

9-89

Location

Loc Qty

Loc Code

FG

10

100664

5

113640

2

115522

3

ST538

38

118387

38

NAS1515H3L

Purchased

No

230

Each

293.0000

4

4

***NAS1515H3I ***

Washer

**

12/12/01

Location

Loc Qty

Loc Code

FG

40

102472

40

ST273

253

m127831

136

m128976

117

x 4

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Shop Packet Print

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Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

140.0000

8

8

NAS1611-013

O-RING

all 10/12/14

Location

Loc Qty

Loc Code

FP001

140

N 130581

m128375

72

x8

m129430

68

AN3C6A

Purchased

No

230

Each

1,058.000

4

4

AN3C6A

Bolt

all 10/12/14

Location

Loc Qty

Loc Code

FG

10

122416

10

ST513

1048

m125709

52

m128769

996

x4

NAS1149C0832R

Purchased

No

230

Each

258.0000

1

1

NAS1149C0832R

Washer

all 10/12/14

Location

Loc Qty

Loc Code

ST277

258

m114915

108

m125807

150

v1

Picklist Print

September-05-14 1:42:39 PM

Page 7

Work Order ID: 124019

124019

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

15.0000

1

1

D3536-25

Gasket Center

all 14/12/14

Location

Loc Qty

Loc Code

FG

6

B125637

87053

2

x1

95328

4

FP001

9

110652

1

123300

7

93696

1

D3794-3

Manufactured No

230

Each

11.0000

1

1

D3794-3

Gasket Aft

all 14/12/14

Location

Loc Qty

Loc Code

FP001

11

B124948

111457

8

x1

122529

2

92658

1

AN3C5A

Purchased No

230

Each

140.0000

34

34

AN3C5A

Bolt

all 14/12/14

Location

Loc Qty

Loc Code

FG

5

M130851

122800

5

x34

ST350

135

M128911

27

M128973

10

M129913

98

Picklist Print

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Page 8

Work Order ID: 124019

124019

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

93.0000

3

3

D3537-1

Wearpad

all valves

Location

Loc Qty

Loc Code

FG

18

79833

8

B125910

88562

10

x3

FP001

75

113839

4

120644

52

120645

18

93945

1

D3535-25

Manufactured No

230

Each

24.0000

1

1

D3535-25

Wearplate Center

all valves

Location

Loc Qty

Loc Code

FG

2

95077

2

B125908

x1

FP002

22

110744

1

123415

20

93278

1

Picklist Print

September-05-14 1:42:39 PM

Page 9

Work Order ID: 124019

124019

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

142.0000

8

8

D3492-3

Plug

ell 10/12/14

Location

Loc Qty

Loc Code

FP001

142

104853

24

B125905

x8

107331

1

112739

1

115807

6

118977

10

123464

100

NAS1149C0332R

Purchased

No

230

Each

3,653.000

38

38

NAS1149C0332R

WASHER

ell 10/12/14

Location

Loc Qty

Loc Code

CA

83

m129682

83

11130325

x38

ST278

3570

122063

41

125654

609

m126319

61

m127306

2500

m127410

75

m127831

26

m128591

75

m129499

183

Picklist Print

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Page 10

Work Order ID: 124019

124019

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

16.0000

1

1

D3488-042

Blade Fitting RH

all 14/12/01

Location

Loc Qty

Loc Code

FP001

15

B124143

115599

7

✓1

120135

7

98887

1

FP002

1

112237

1

ALS4-1032-225

AELS8-1032-225 Purchased

No

230

Each

258.0000

38

38

ALS4-1032-225

Rivnut

all 14/12/01

Location

Loc Qty

Loc Code

FG

30

M127028

30

1130579

ST267

228

x38

M127028

10

M127092

26

M128179

192

D3492-1

Manufactured No

230

Each

121.0000

8

8

D3492-1

Plug

all 14/12/01

Location

Loc Qty

Loc Code

FP001

121

B125904

111578

2

x8

114879

7

119646

2

120519

50

122460

60

Picklist Print

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Page 11

Work Order ID: 124019

124019

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

11.0000

1

1

D3793-1

Wearplate Fwd

all 12/12/14

Location

Loc Qty

Loc Code

FP002

11

B124210

112741

2

120212

8

92382

1

AN8C35A

Purchased No

230

Each

73.0000

1

1

AN8C35A

Bolt

all 12/12/14

Location

Loc Qty

Loc Code

FG

4

1130784

121275

4

FP001

69

m126293

29

m127823

1

m130114

39

MS21083C8

Purchased No

230

Each

64.0000

1

1

MS21083C8

Nut

all 12/12/14

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

Picklist Print

Page 12

September-05-14 1:42:39 PM

Work Order ID: 124019

124019

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 145.0000 8 8

D2745

Bushing

ll whuber

Location	Loc Qty	Loc Code
ST010	145	
107336	4	13125895
113176	2	
117099	7	
119572	51	
122643	73	
90323	2	
93336	6	

AN6C44A Purchased No 230 Each 45.0000 4 4

AN6C44A

Bolt

ll whuber

Location	Loc Qty	Loc Code
FG	2	
103964	2	11130863
ST333	43	
m128319	2	
m128700	1	
m129199	40	

D3532-1 Manufactured No 250 Each 34.0000 2 2

D3532-1

Spacer

124482
DEC 03 2014

DAS
46
9-89

DAS
88
9-89

Location	Loc Qty	Loc Code
ST048	34	
115855	3	
117198	3	
122723	21	
123513	7	

Picklist Print

September-05-14 1:42:39 PM

Work Order ID: 124019

124019

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

64.0000

2 2

MS21083C8

Nut

DAS
46
9-89

**

DAS
06
9-89

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

NAS1149D0863J

Purchased

No

250

Each

795.0000

2 2

NAS1149D0863J

Washer

DAS
46
9-89

**

DAS
06
9-89

Location

Loc Qty

Loc Code

ST276

595

118078

2

125268

586

125484

7

ST2776

200

125635

200

D3493-1

Manufactured

No

250

Each

139.0000

2 2

D3493-1

Washer

DAS
46
9-89

**

DAS
06
9-89

DEC 03 2014

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

129

109105

129

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

Picklist Print

Page 14

September-05-14 1:42:39 PM

Work Order ID: 124019

124019

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

62.0000

2

2

AN8C21A

Bolt

**

DEC 03 2014

DAS

DAS

46

9-89

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

60

m127061

2

m127823

3

m129888

55

86

9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C6A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER

NO 174019 MJS

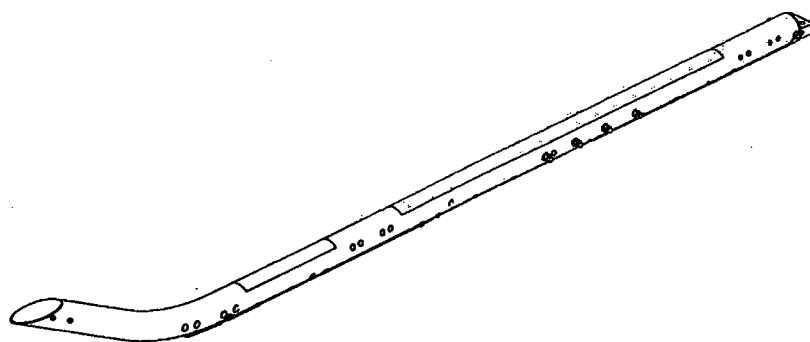
RELEASED
2013-08-13

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-AJ-5-B1-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART 3-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24894-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

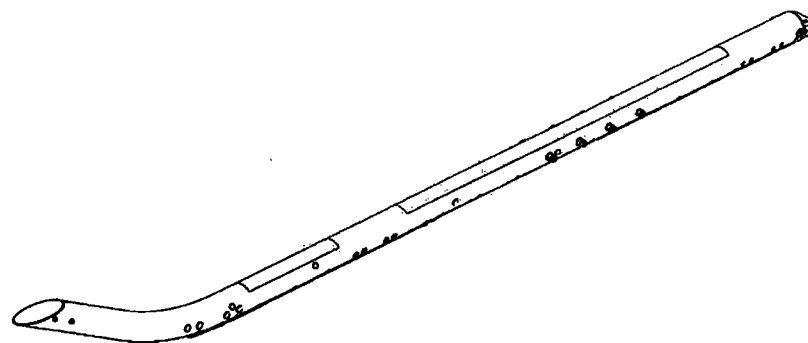
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
SCALE
NTS

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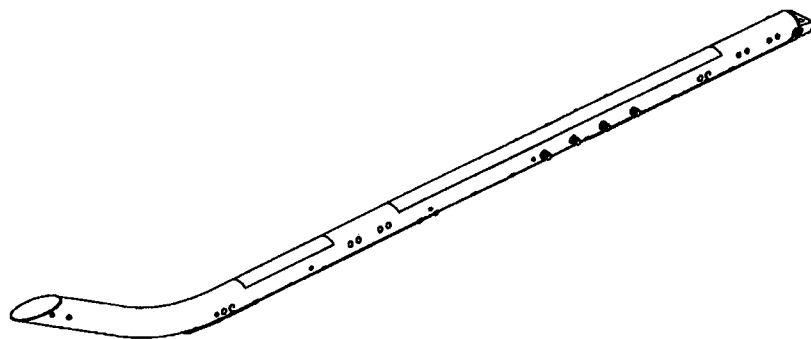
D2750-041 350 SKIDTUBE ASSEMBLY, LH



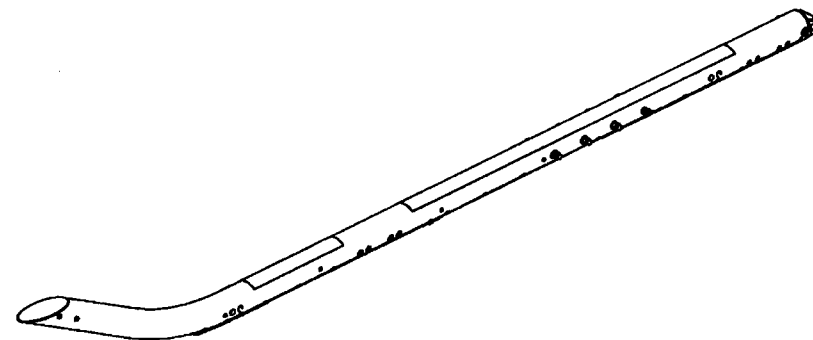
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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MFG. APPR.		D2750	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

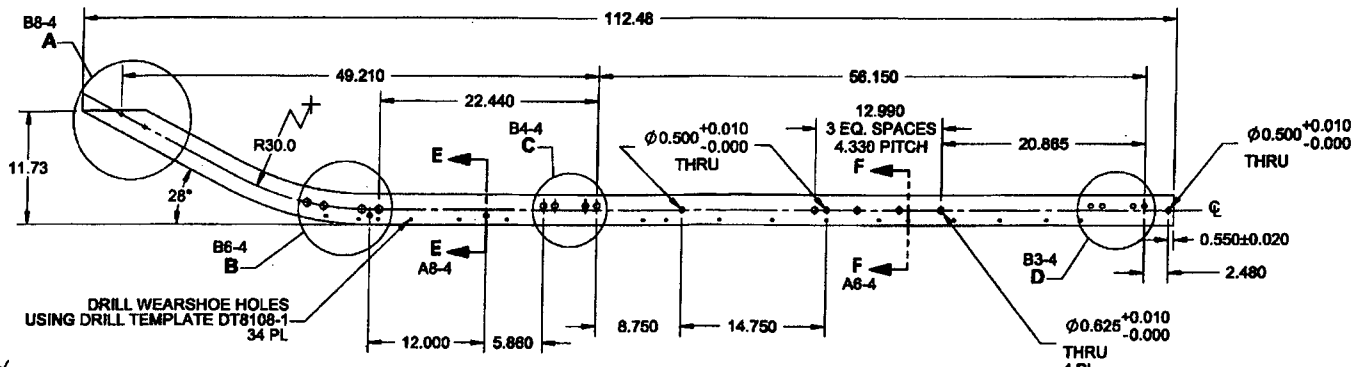


D2750-044 350 SKIDTUBE ASSEMBLY, RH

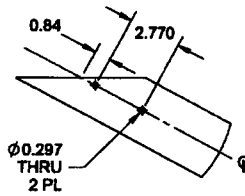
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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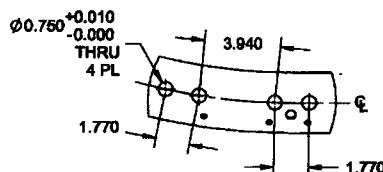
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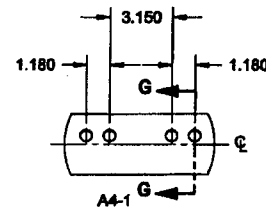
D2750-1 LH SKIDTUBE



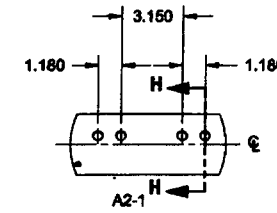
DETAIL A
SCALE 2X



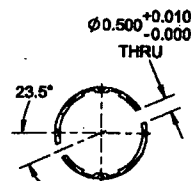
DETAIL B
SCALE 2X



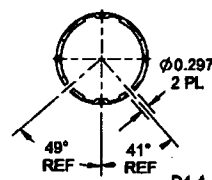
DETAIL C
SCALE 2X



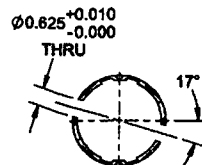
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SCALE 2X



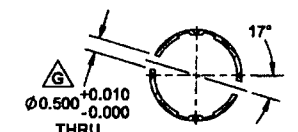
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

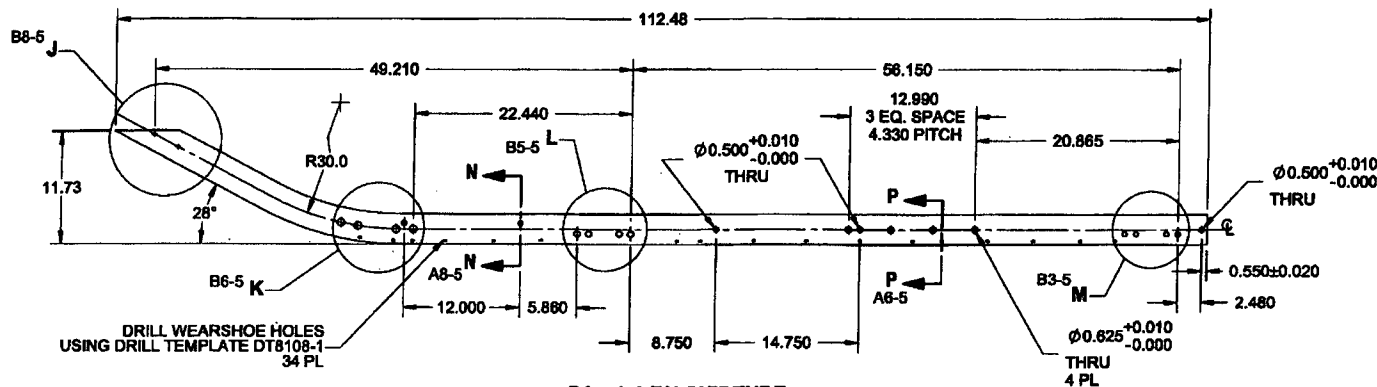


SECTION H-H
SCALE 3X, 4 PL

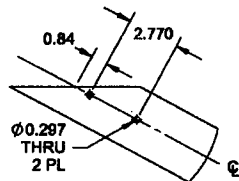
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DESIGN	MM	DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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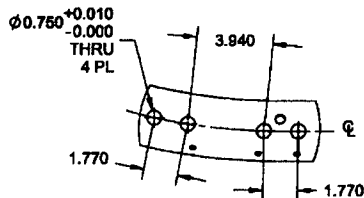
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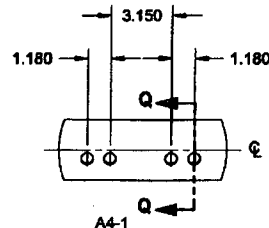
D2750-2 RH SKIDTUBE



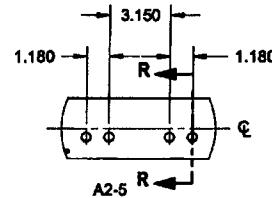
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SCALE 2X



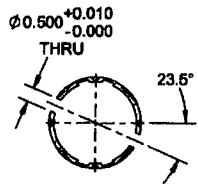
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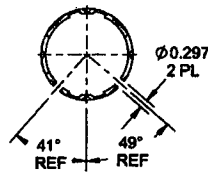
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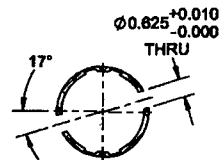
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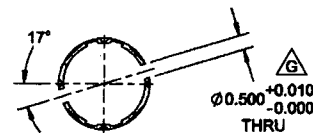
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

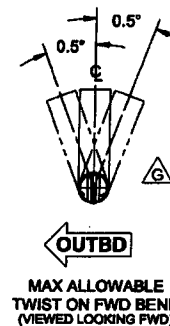
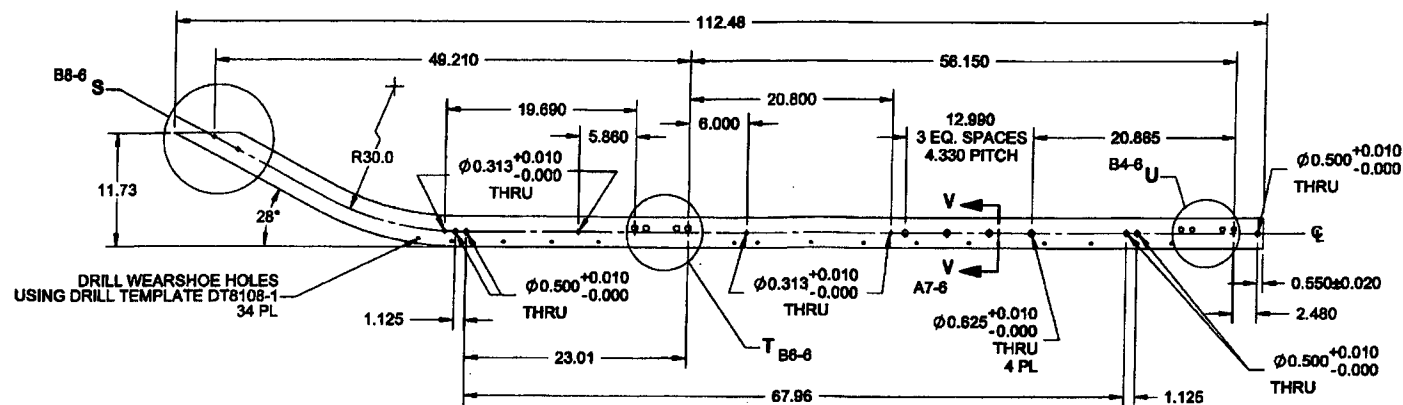


SECTION R-R
SCALE 3X, 4 PL

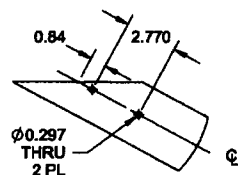
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 5 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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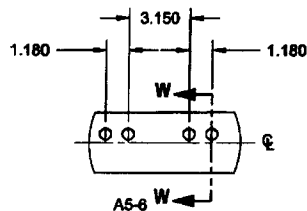
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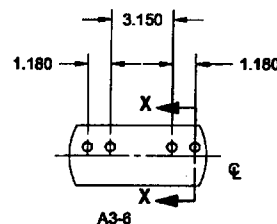
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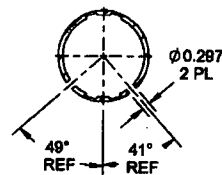
DETAIL S
D8-6
SCALE 2X



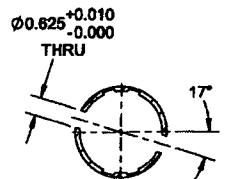
DETAIL T
C5-6
SCALE 2X



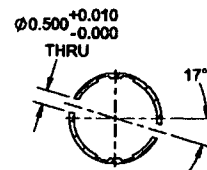
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B8-6
SCALE 3X, 4 PL



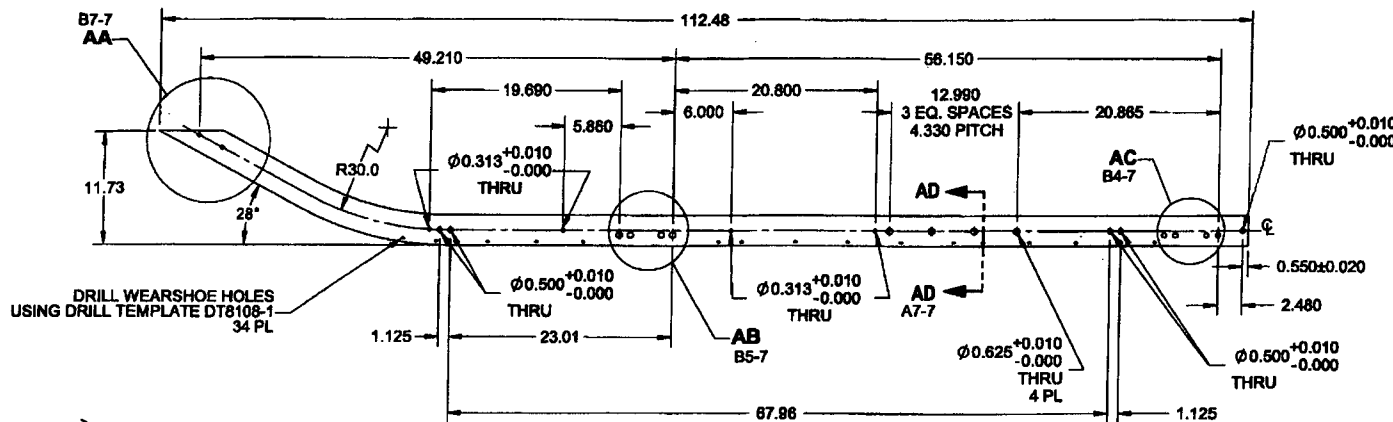
SECTION X-X
B4-6
SCALE 3X, 4 PL

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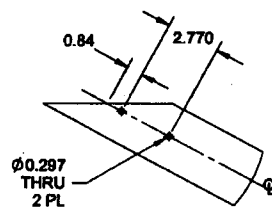
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APPROVED		SHEET 6 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
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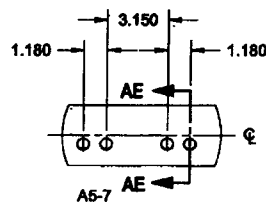
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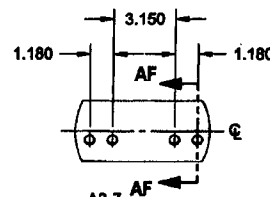
D2750-4 RH SKIDTUBE



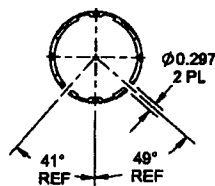
DETAIL AA
D7-7
SCALE 2X



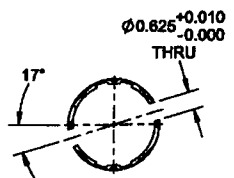
DETAIL AB
A5-7 AE C4-7
SCALE 2X



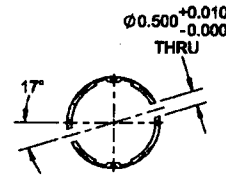
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A3-7 AF D3-7
SCALE 2X



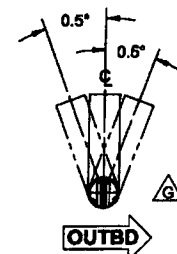
SECTION AD-AD
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL



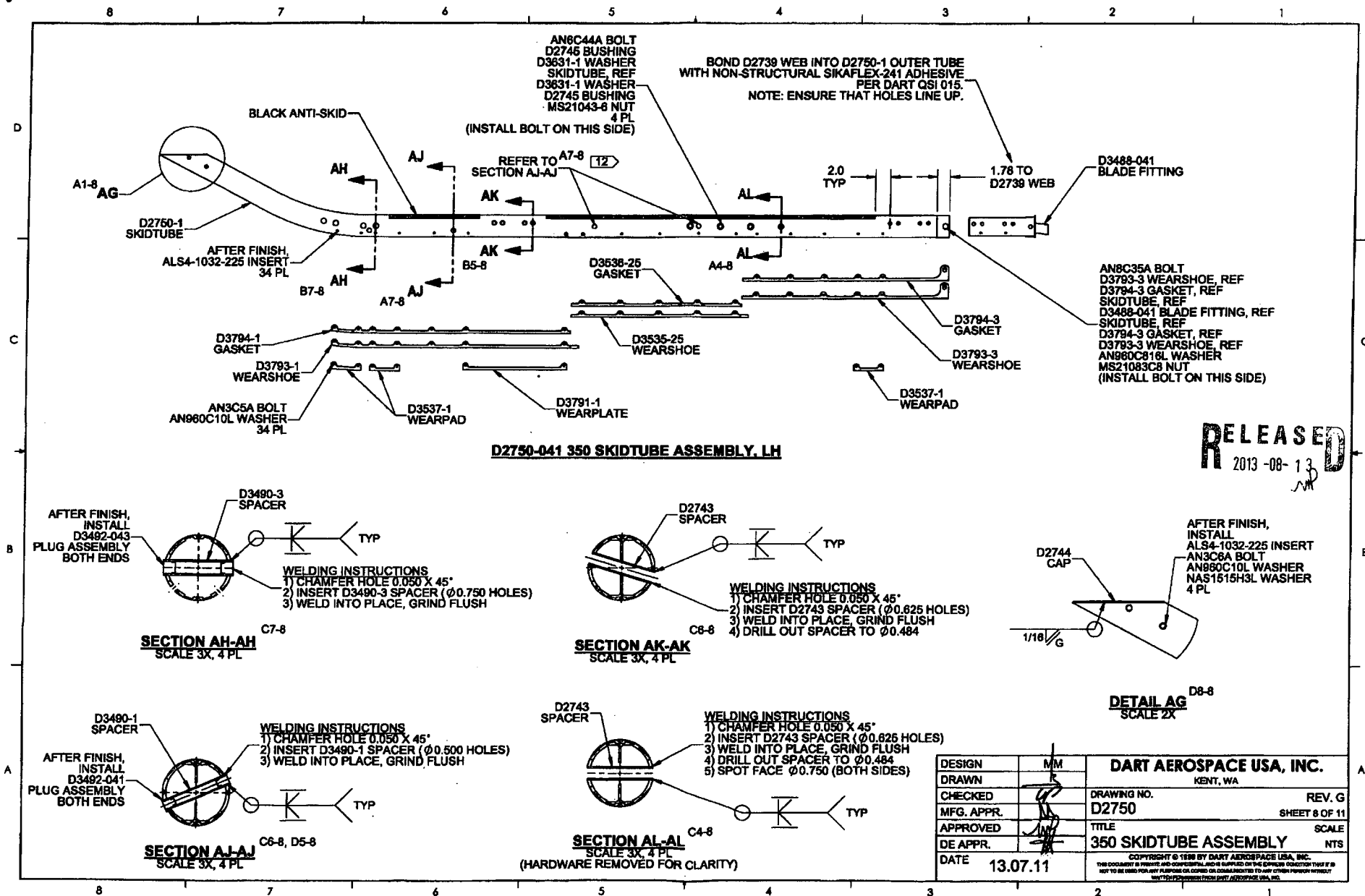
SECTION AF-AF
B4-7
SCALE 3X, 4 PL



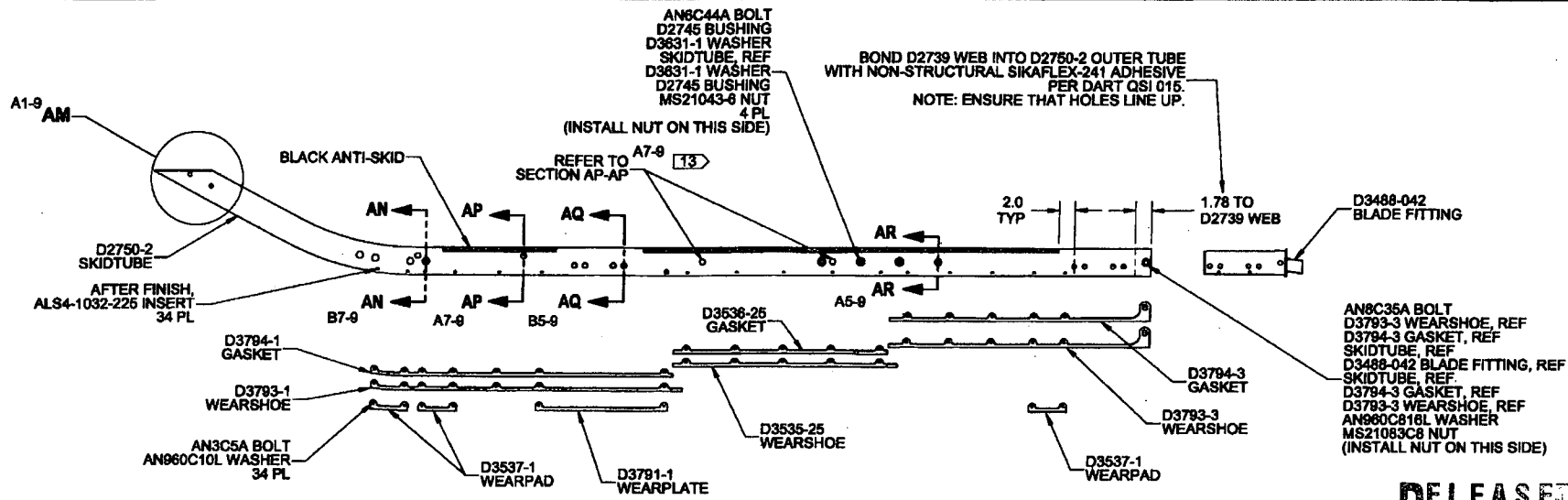
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

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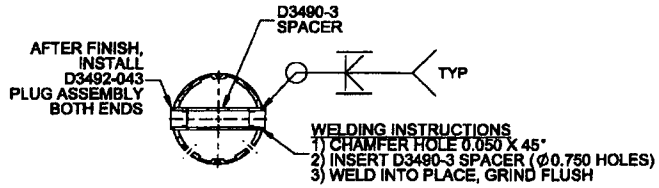


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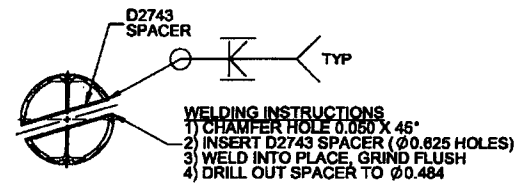


D2750-042 350 SKIDTUBE ASSEMBLY, RH

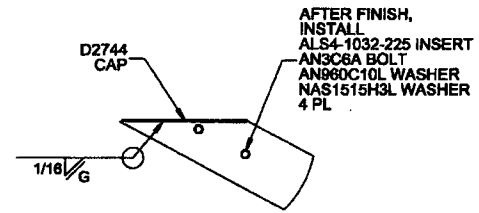
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2013-08-13



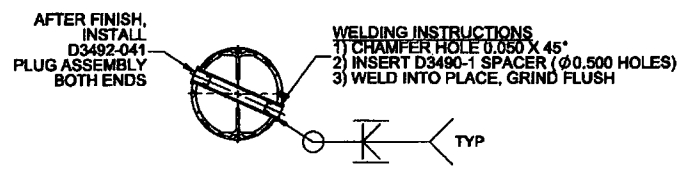
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SCALE 3X, 4 PL



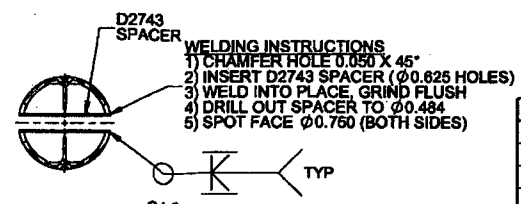
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



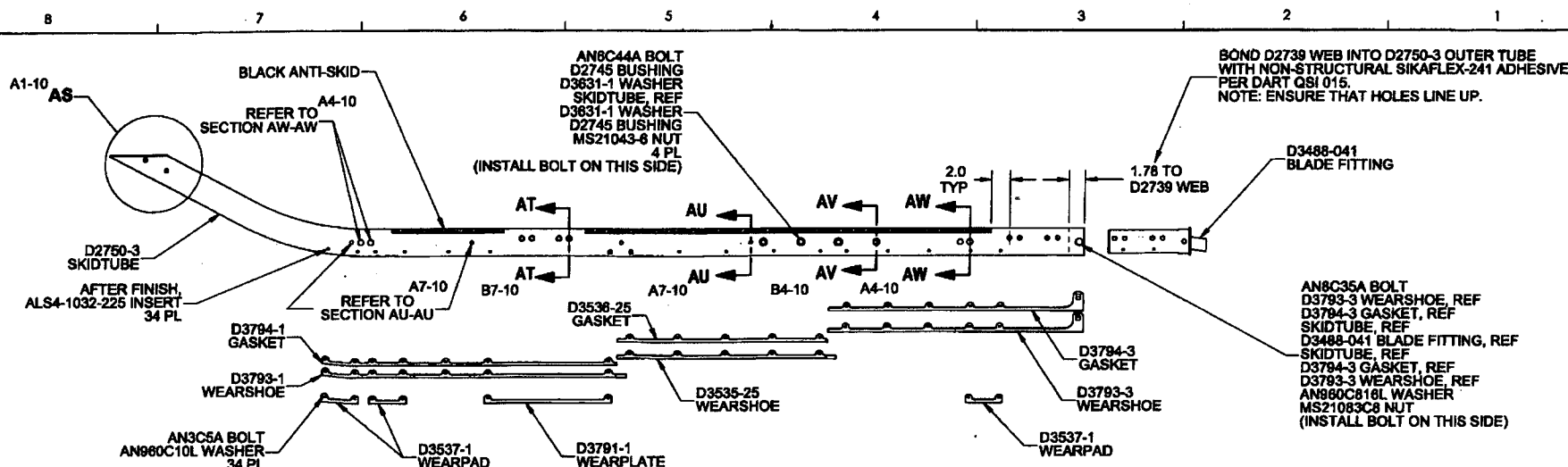
SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

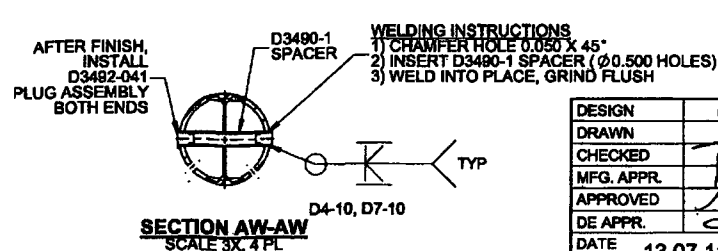
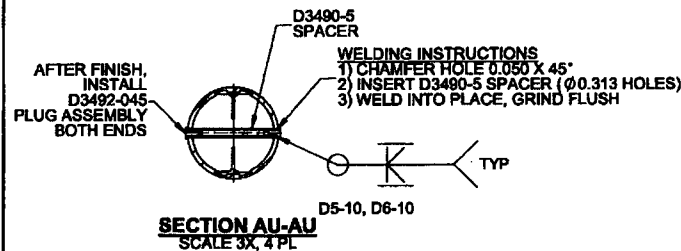
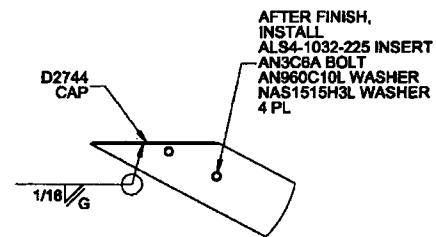
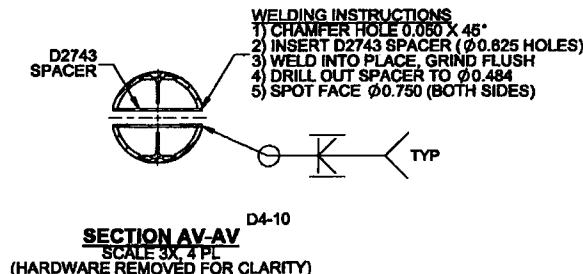
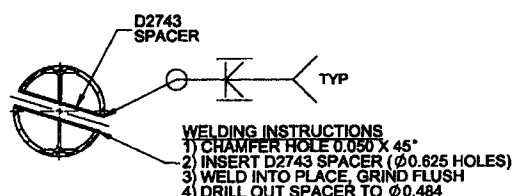
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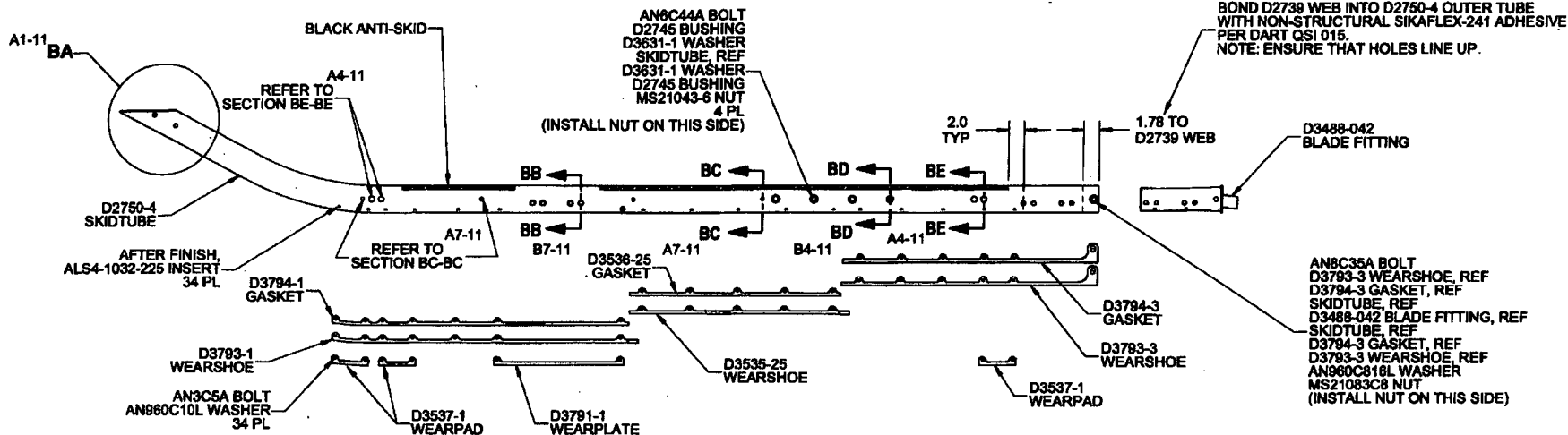
D2750-043 350 SKIDTUBE ASSEMBLY, LH

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2013-08-13

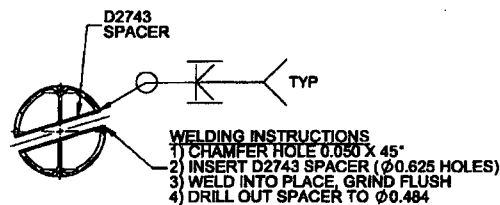


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8 7 6 5 4 3 2 1



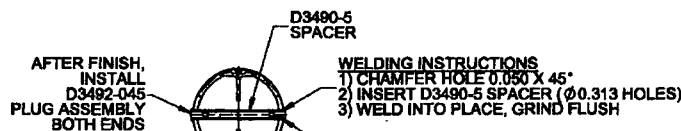
D2750-044 350 SKIDTUBE ASSEMBLY, RH



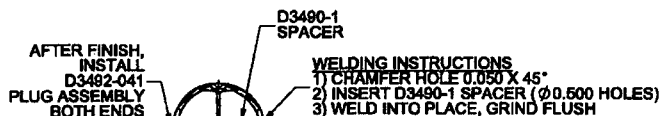
SECTION BB-BB
SCALE 3X, 4 PL



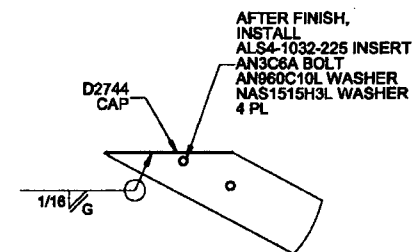
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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